

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014373**Date Inspected:** 26-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as 7EW (punch list item 412). The weld designations reviewed are as follows:

7EW

1. SSD-PP59-067

2. CSD3-PP59-061

This QA inspector performed UT of approximately 10% of the repaired area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member(s) is/are identified as SP to EP hold backs (Inspection request # 005835). The weld designations reviewed are as follows:

8AW

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1. CA047-001
2. SEG043A-030

7EW

1. CA044-001
2. CA043-005

9AE+9BE

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 021 located at DP710-001 bike path side of segment. Welder is identified as Mr. (053753). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-3213-B-U3b.

7DW

Flux Core Arc Welding (FCAW) welding was performed on weld joint 100 located at SEG039C-001 cross beam side of segment. Welder is identified as Mr. Yu Huiye (045143). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2232-Tc-U4b-F.

8BW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 018~013 located at DP652-001 cross beam side of segment. Welder is identified as Mr. Dong Haitao (067183). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2114-FCM-1.

8CW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 007~012 located at DP653-001 cross beam side of segment. Welder is identified as Mr. Dong Haitao (067183). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2114-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 044 located at SEG047* cross beam side of segment. Welder is identified as Mr. Dong Haitao (067609). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2114-Tc-U4b-FCM-1.

9AW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 006 located at CA056 cross beam side of segment. Welder is identified as Mr. Dong Haitao (067183). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2114-Tc-U4b-FCM-1.

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9AE

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 006 located at CA057 cross beam side of segment. Welder is identified as Mr. Dai Lu (048659). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2114-Tc-U4b-FCM-1.

9BE

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 049 located at SEG052* cross beam side of segment. Welder is identified as Mr. Dai Lu (048659). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2114-Tc-U4b-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 005 and 007 located at EP163 cross beam side of segment. Welder is identified as Mr. Huang Jian (069841). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-4G (4F)-Repair-1 and WR13183 procedure.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (150-0042-2372), who represents the Office of Structural Materials for your project.

Inspected By: Alaniz, Joe

Quality Assurance Inspector

Reviewed By: Carreon, Albert

QA Reviewer